

Work Order ID 53832-2

November 19, 2009 11:37:53 AM

ASAP

Spht

Item ID: D4011-1

Revision ID:

Item Name: Clamp, Short

Start Date: 11/19/09 Start Qty: ~~80.00~~ ⁶⁶

Required Date: 11/24/09 Req'd Qty: 80.00

Reference:

Approvals: Process Plan: *U*

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4011

B

101



Waterjet

FLOW CNC Waterjet

Memo

cut per drwg D4011

Rev. B Prog Rev: B

Deburr is necessary

0.00

0.00

HB 9-11-21

102



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

HB 9-11-21

103



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

2) 5 or 11/23

count

(120) /

(120)

Work Order ID 53832

November 19, 2009 11:37:54 AM

Page 2

Item ID: D4011-1

Revision ID:

Item Name: Clamp, Short

Start Date: 11/19/09 Start Qty: 80.00

Required Date: 11/24/09 Req'd Qty: 80.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

104



Small Fab

Small Fab

Memo

Form as per drwg
D4011 Rev.B

0.00

0.00

SB 09/11/24

66 - 8

105



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

SB 09/11/24

count
x66 8

130



Packaging

Packaging

Identify as per dwg & Stock Location: 408

Memo

0.00

0.00

PC 09/11/25 66

Work Order ID 53832

November 19, 2009 11:37:54 AM



Item ID: D4011-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Clamp, Short

Start Date: 11/19/09 Start Qty: 80.00



Cust Item ID:

Required Date: 11/24/09 Req'd Qty: 80.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/26

PH 09-11-25

Print

November 20, 2009 8:38:02 AM

Page 1

Work Order ID: 53832



Parent Item: D4011-1



Parent Item Name: Clamp, Short

Start Date: 11/19/09

Required Date: 11/24/09

Comments: IPP RevA: New issue 09.10.26 DD verified by:JLM
dwg chg Prelim-B 09.11.12 DD verified by:EC
dwg 09.11.18 DD verified by:JLM

IPP RevB:
IPP RevC: revC as per

Start Qty: 80.00

Required Qty: 80.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
M304S14GA		Purchased	No				sf	25.9521	4.8000	7.2		



304SS sheet .080



B 9-11-21

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
MAT	25.9521	
110993Q	25.9521	

Location

Main Warehouse

MAT

25.9521

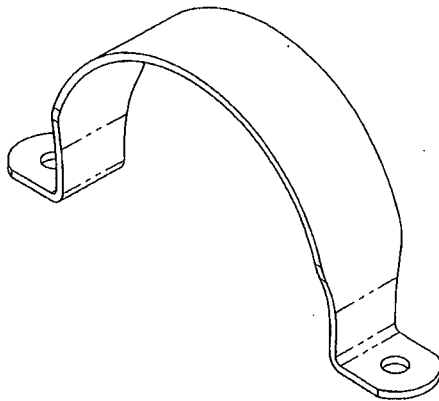
110993Q

25.9521

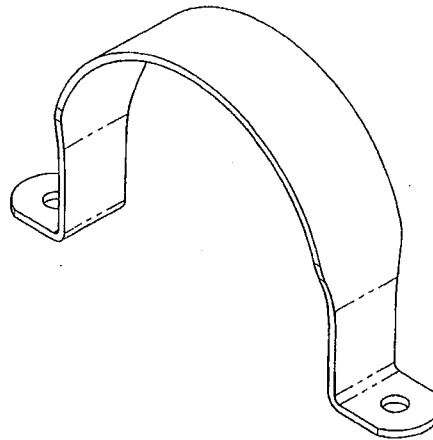
110993

120

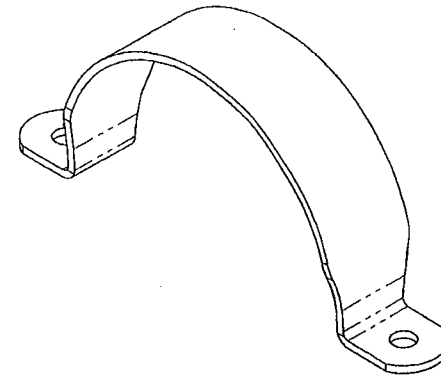
W/O 53832



D4011-1 CLAMP, SHORT



D4011-3 CLAMP, LONG



D4011-5 CLAMP, SHORT (OEM)

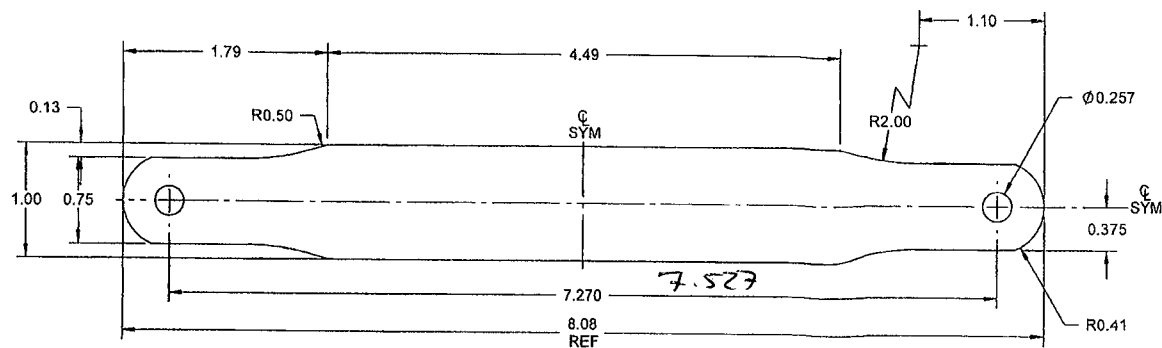
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 14 GAUGE (0.078 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S14GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4011-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.02 lbs EACH

B	SHORTEN HEIGHT OF -1/-3 CLAMPS BY 0.125, ADDED -.5. REASON: PROVIDE MORE CLEARANCE UPON INSTALLATION ON OEM SKID TUBES		MB	09.11.11
A	NEW ISSUE		MB	09.10.21
REV.		DESCRIPTION	BY	DATE
DESIGN				
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	09.11.11			

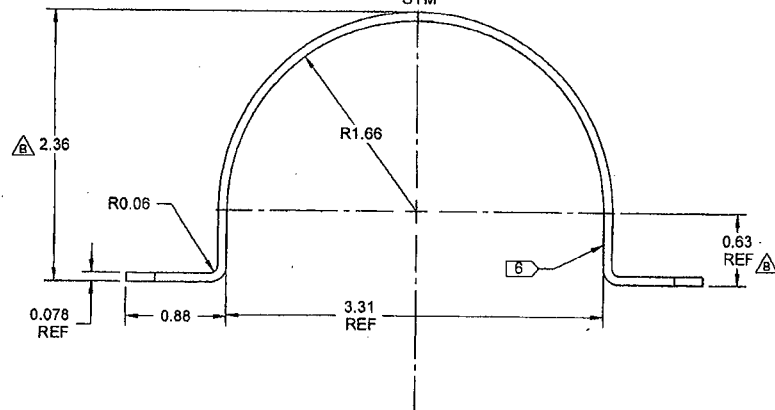
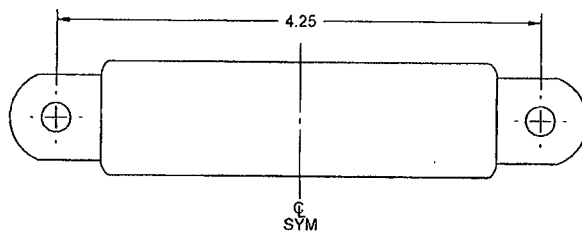
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4011	REV. B
TITLE CLAMP	SCALE NTS
<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

8 7 6 5 4 3 2 1



4053832

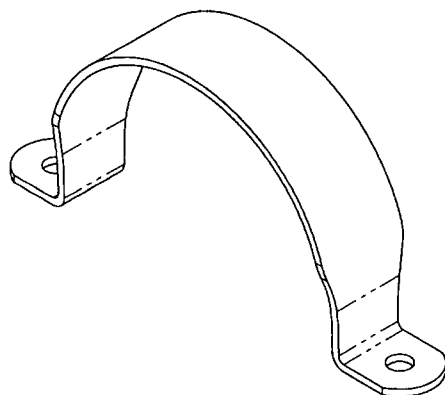
D4011-1F CLAMP, SHORT FLAT PATTERN



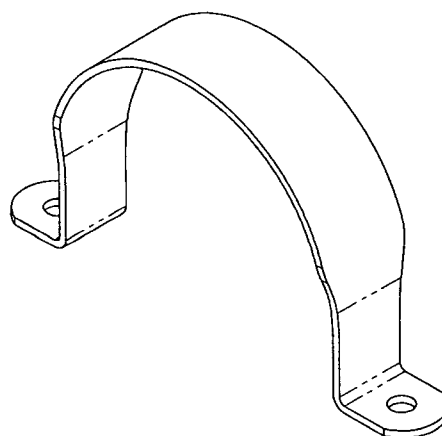
D4011-1 CLAMP, SHORT
(MAKE FROM D4011-1F)

DESIGN	1	DART AEROSPACE LTD	
DRAWN	1	HAWKESBURY, ONTARIO, CANADA	
CHECKED	1	DRAWING NO. D4011	REV. B
MFG. APPR.	1	SHEET 2 OF 4	
APPROVED	1	TITLE	SCALE
DE APPR.	1	CLAMP	NTS
DATE	09.11.11	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONTAINS TRADE SECRETS. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

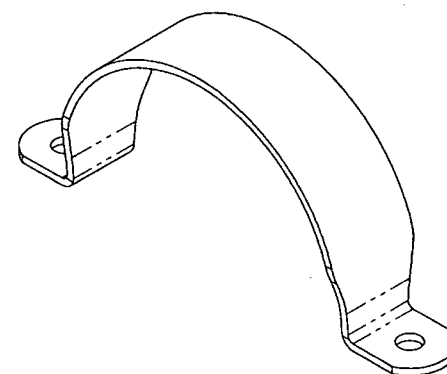
8 7 6 5 4 3 2 1



D4011-1 CLAMP, SHORT



D4011-3 CLAMP, LONG



D4011-5 CLAMP, SHORT (OEM)

53832

RELEASED
2009-11-24
MP

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 14 GAUGE (0.078 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S14GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4011-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.02 lbs EACH

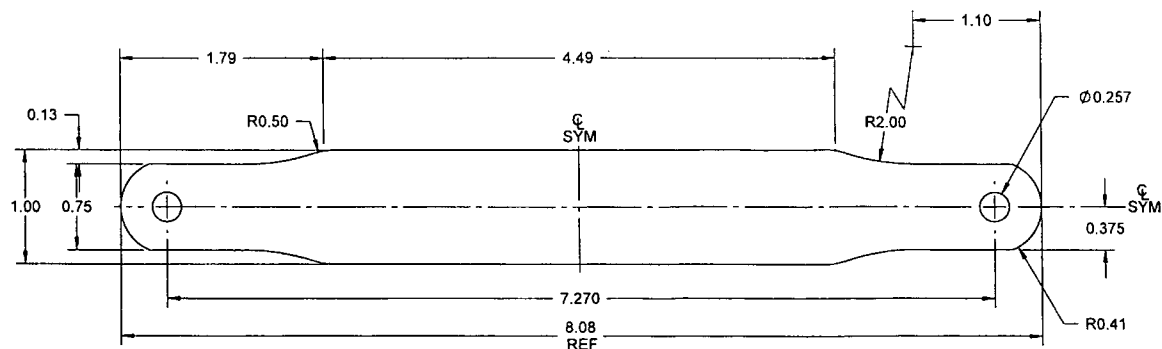
B	SHORTEN HEIGHT OF -1/3 CLAMPS BY 0.125; ADDED -.5. REASON: PROVIDE MORE CLEARANCE UPON INSTALLATION ON OEM SKIDTUBES	MB	09.11.11
A	NEW ISSUE	MB	09.10.21
REV.	DESCRIPTION	BY	DATE
DESIGN	1		
DRAWN	1		
CHECKED	1		
MFG. APPR.	1		
APPROVED	1		
DE APPR.	1		
DATE	09.11.11		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

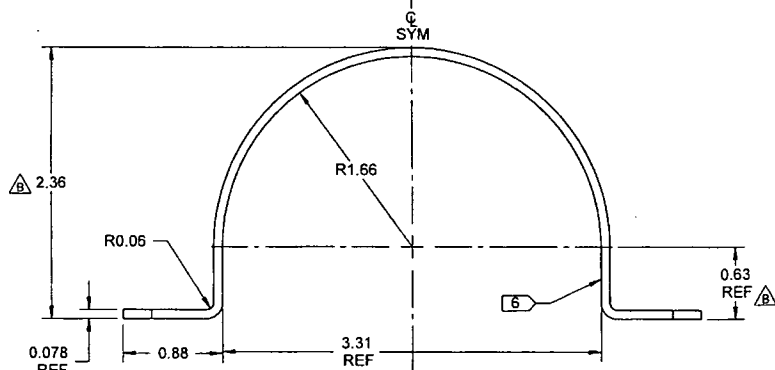
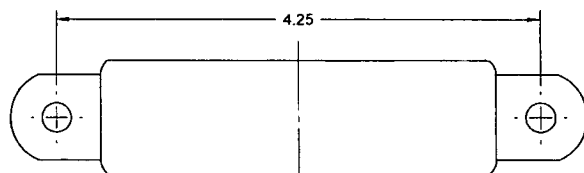
DRAWING NO. **D4011** REV. B
SHEET 1 OF 4
TITLE **CLAMP** SCALE NTS

COPYRIGHT © 2009 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD.

8 7 6 5 4 3 2 1



D4011-1F CLAMP, SHORT FLAT PATTERN



**D4011-1 CLAMP, SHORT
(MAKE FROM D4011-1F)**

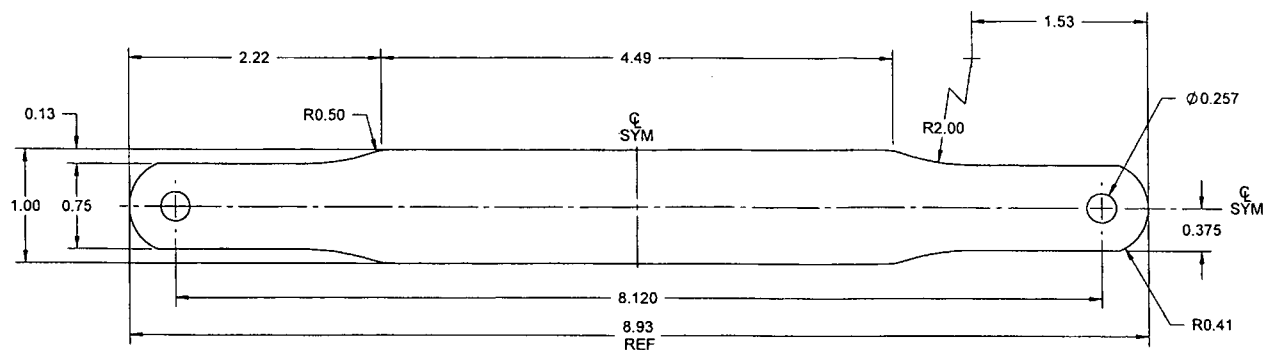
53832

RELEASED
2009-11-24
MP

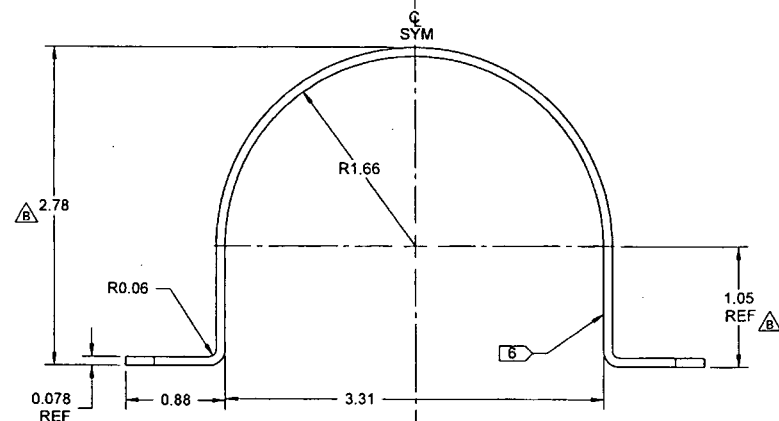
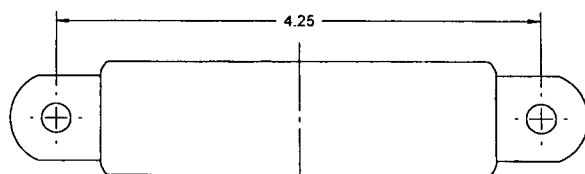
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. B
MFG. APPR.		D4011	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		CLAMP	NTS
DATE	09.11.11	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1



D4011-3F CLAMP FLAT PATTERN, LONG



D4011-3 CLAMP, LONG
(MAKE FROM D4011-3F)

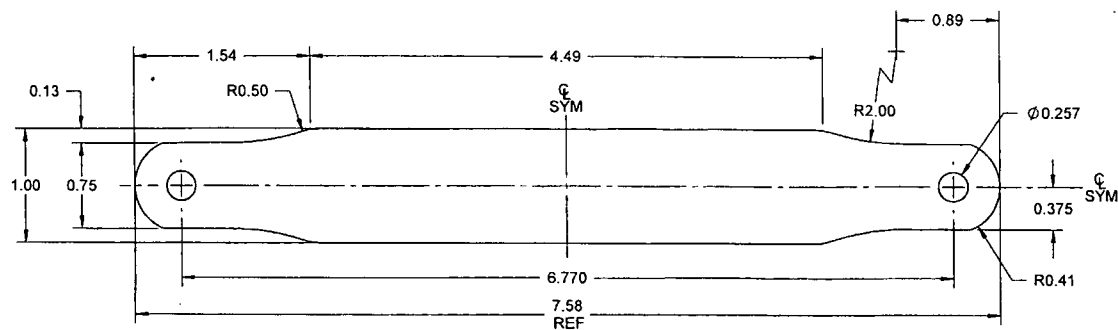
53832

RELEASED
2009-11-24
MP

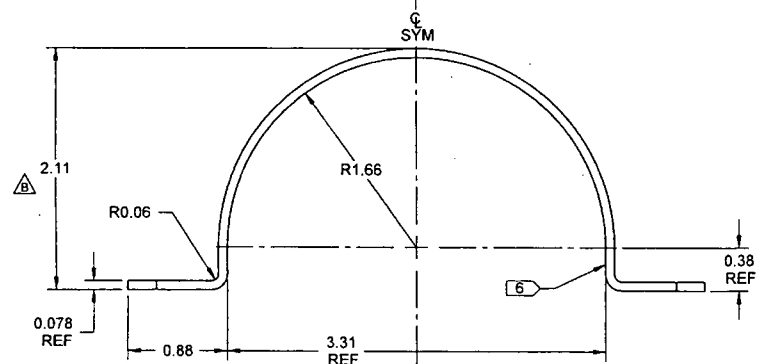
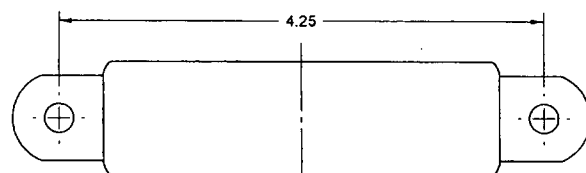
DESIGN	1	DART AEROSPACE LTD	
DRAWN	A	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ALS	DRAWING NO.	REV. B
MFG. APPR.	120	D4011	SHEET 3 OF 4
APPROVED	120	TITLE	SCALE
DE APPR.	120	CLAMP	NTS
DATE	09.11.11	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1



D4011-5F CLAMP, SHORT (OEM) FLAT PATTERN



D4011-5 CLAMP, SHORT (OEM)
(MAKE FROM D4011-5F)

53832

RELEASED
2009-11-24
MP

DESIGN	1	DART AEROSPACE LTD	
DRAWN	1	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ALS	DRAWING NO.	REV. B
MFG. APPR.	10	D4011	SHEET 4 OF 4
APPROVED	10	TITLE	SCALE
DE APPR.	10	CLAMP	NTS
DATE	09.11.11	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1